

303 R 0.625"

Work Order ID 73832



Page 1

Friday, September 16, 2011 11:43:56 AM

Item ID: D3873-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 9/16/2011 Start Qty: 400.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 400.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3873

B

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA806 & DWG D3873 ,

FOLIO REV: *1/1*DWG REV: *1/1*

2-DEBURR AS REQUIRED

400 0 *LF 11/16/11*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

400 0 *LF 11/16/11*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73832

Friday, September 16, 2011 11:43:56 AM



Page 2

Item ID: D3873-1

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 11/11/06		400	0		
130 Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00						SP 11-11-07	
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 11/11/07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 11:43:53 AM

Page 1

Work Order ID: 73832



Parent Item: D3873-1



Parent Item Name: Bushing

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 400.00

Required Qty: 400.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625 		Purchased	No			100	f	15.2000	0.06	25.26316			
303 Round Bar 0.625"													



24.479'

SL 11/11/04

Location

Loc Qty

Loc Code

MAT028

15.2

110167

3.2

118400

12

[119009]

24.479'

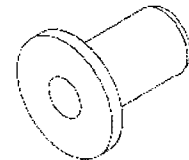
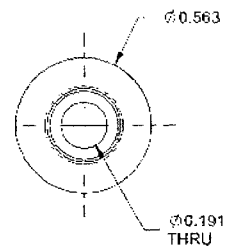
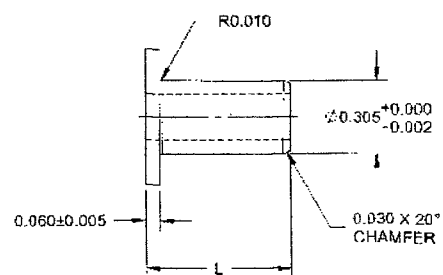
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3873-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3873-1	0.600	0.010
D3873-3	0.120	0.006
D3873-5	0.270	0.007

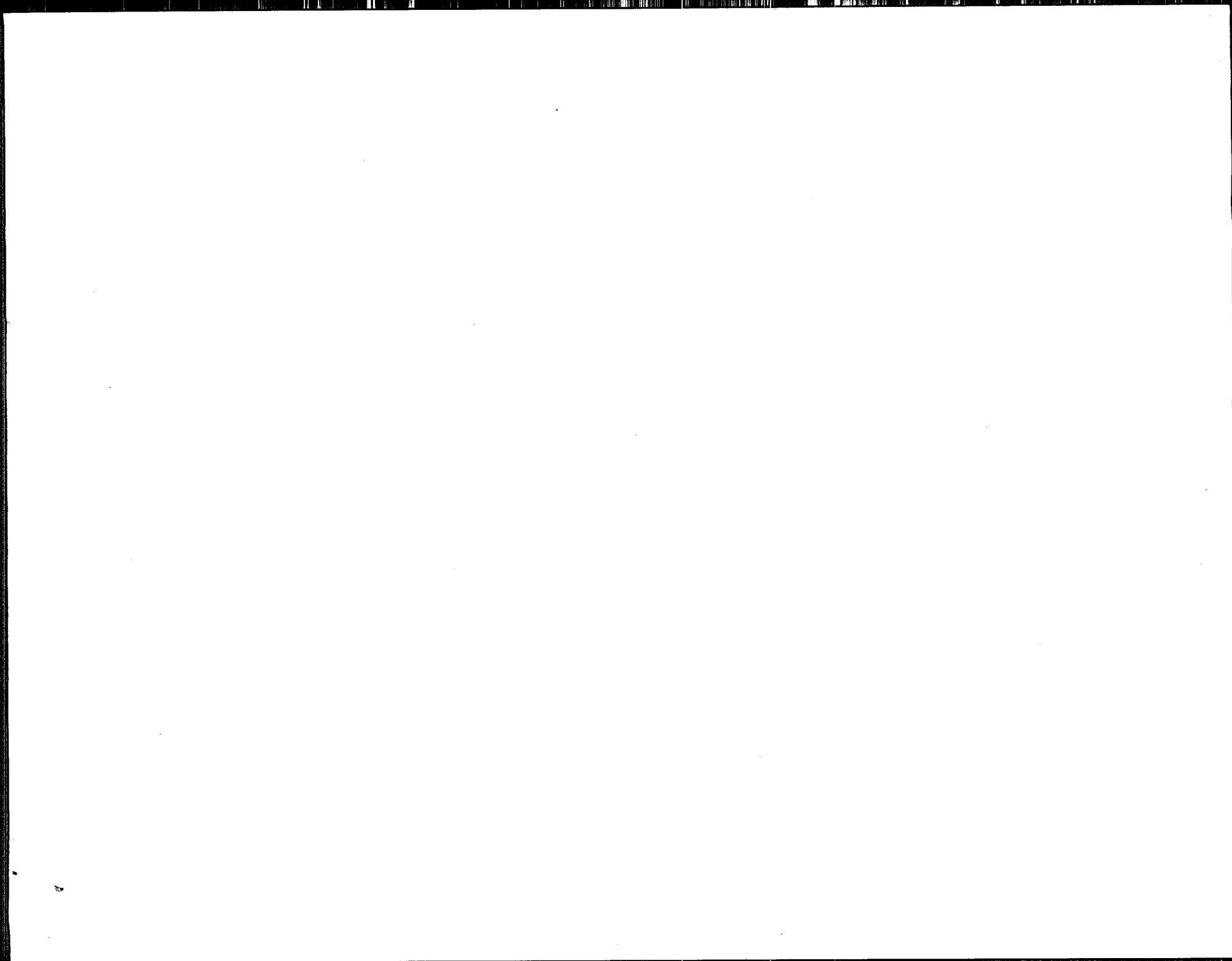


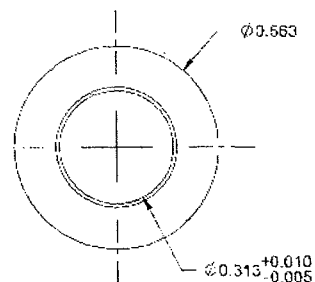
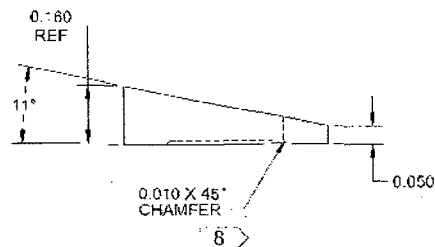
NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

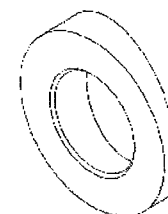
RELEASED
2011-06-12

REV.	DESCRIPTION	BY	DATE
C	ADD D3873-3/-5/-7 (2N BG-1 & BG-2)	RF	11.06.14
B	Ø0.562 WAS Ø0.53 (C3 1, TO FIT TRIBAC DIRT)	CP	10.07.22
A	NEW ISSUE	MB	09.01.07
DESIGN	CP	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.	EE	D3873	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	BUSHING	NTS
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C D3873-7 SPACER



NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART GSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.005 lbs
- 8) IT IS ACCEPTABLE TO BE DEBURR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RE	PORT HADLOCK, WA	
CHECKED	CH	DRAWING NO.	REV. C
MFG. APPR.	CH	D3873	SHEET 2 OF 2
APPROVED	CH	TITLE	SCALE
DE APPR.	CH	BUSHING	NTS
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